

Work Order ID 133896

Tuesday, June 23, 2015 3:14:07 PM

133896

Page 1

Item ID: D3859-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate
 Start Date: 6/20/15 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 6/23/15 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: JUN 24 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3859	B

100	FLOW WATER JET	0.00				5	Ø		Jm15-6-25
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100

Waterjet

FLOW CNC Waterjet

304-063

Memo

1-Cut as per Dwg D3859-1

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00				5	Ø		Jm15-6-25
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110

QC

Quality Control

Memo

120	QC8- Inspect parts - second check	0.00				5			DAS 38 2-89 JUN 26 2015
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120

QC

Quality Control

Memo

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Tuesday, June 23, 2015 3:14:07 PM

133896

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 6/20/15 **Start Qty:** 5.00 ***5***

Cust Item ID:

Required Date: 6/23/15 **Req'd Qty:** 5.00 ***5***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID[illegible]

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
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**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

130

0.00

130

Large Fab

0.00

Large Fab

Memo

1-Weld D4379-5 cups as per dwg D3859

A/R 316L stainless steel rod Batch: 125825

2-Weld hard facing as per Dwg D3859

A/R 2059B Hard Coat rod Batch: 130193

*****use DT9462 for welding*****

140

QC9- Inspect visual per QSI004- Fusion Welds

0.00

140

QC

Memo

0.00

Quality Control

DAS

9

9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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NOV 24 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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133896

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>St64</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

NOV 24 2015

MLJ 15-11-25

MLJ 15-11-28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
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OTHER : ☐					

Picklist Print

Tuesday, June 23, 2015 3:14:06 PM

Page 1

Work Order ID: 133896

133896

Parent Item: D3859-041

D3859-041

Parent Item Name: Wearplate

Start Date: 6/20/15

Required Date: 6/23/15

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 09-02-03 new issue DD verified by:EC
14.04.30 as per dwg rev.b DD verified by:JLM

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4379-5		Manufactured	No			130	Each	33.0000	6	30			

D4379-5

Wearplate Cup

15-11-23 JLM

Location	Loc Qty	Loc Code
ST103	4	
126889	4	
WA001	29	
129613	10	
133126	19	

M304S16GA

Purchased

No

100

sf

229.3076

0.85

5

Jm15-6-25

M304S16GA

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT019	229.3076	
m131384	95.0176	
m131503	134.29	

131503

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

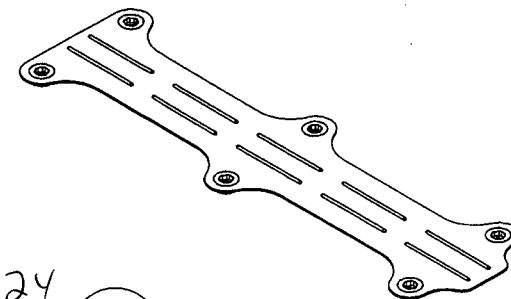
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ITEM NO.	QTY.	P/N	DESCRIPTION
	X	D3859-041	WEARPLATE
1	1	D3859-1	WEARPLATE
2	6	D4379-5	WEARPLATE CUP

△ B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO
REVISIONS

NO. 133896 MLC
15-06-24



2059B HARDCOAT
10 PL

0.06
TO
0.13
HIGH

C
SYM

0.38

1.0
TYP

3.1
TYP

1.50
REF

1.00

HARDCOAT WELD
SURFACING
REF

6 PL
1/32

6

D3859-041 WEARPLATE

D3859-1 WEARPLATE (1)

INSTALL D4379-5 FLUSH
WITH THIS SURFACE
TYP

D4379-5 WEARPLATE CUP (6) △ B

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3859-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.58 lbs
- 8) WELD PER DART QSI 004

RELEASED

2014 MAR 29

ECN 14-544

APPROVED

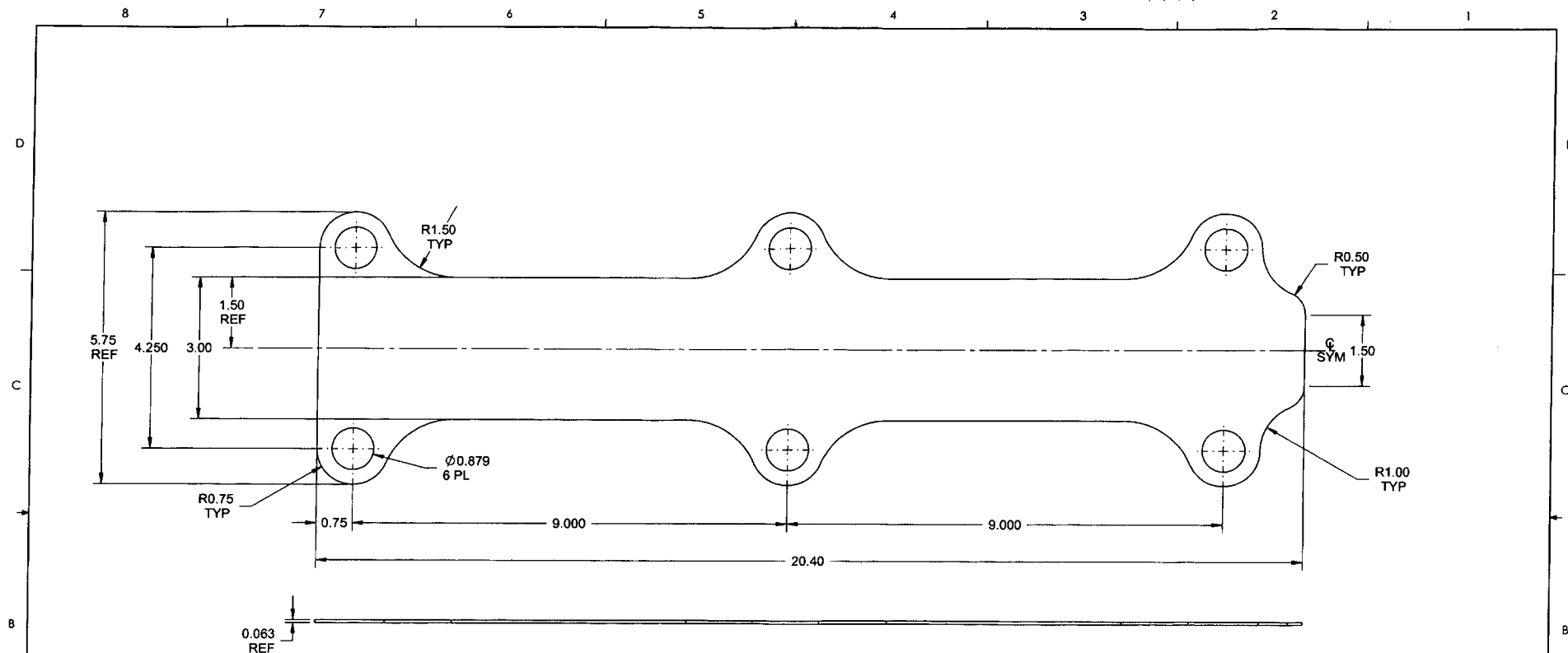
B	D4379-5 CUP WAS D3009-3 CUP	DB	14.03.05
A	NEW ISSUE	HS	09.01.26
REV.	DESCRIPTION	BY	DATE
DESIGN	HS		
DRAWN	DB		
CHECKED	AP		
MFG. APPR.	DD		
APPROVED	MP		
DE APPR.	DS		
DATE	14.03.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3859
TITLE
WEARPLATE

REV. B
SHEET 1 OF 2
SCALE
NTS

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D3859-1 WEARPLATE

RELEASED
2014 MAR 29

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK), PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 (REF DART SPEC M304S16GA)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.29 lbs

APPROVED	DESIGN	HS	DART AEROSPACE LTD	
	DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	AP	DRAWING NO.	REV. B
	MFG. APPR.	DD	D3859	SHEET 2 OF 2
	APPROVED	MP	TITLE	SCALE
	DE APPR.	DS	WEARPLATE	NTS
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